

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017328**Date Inspected:** 02-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** OBG, Tower**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

Outside yard

B-CWR 1980 Rev 0 (SPCM UT excessive depth)

This QA Inspector was notified via email for verification of B – CWR1980 R0 at 0900 hours the following was observed:

- The component for verification was identified as VP3014-001-030
- Weld repair was to be performed on locations where rejectable indications were found by ultrasonic testing
- ZPMC CWI Chen Xi was present on site to direct and record all repair work.

B-CWR 1981 Rev 0 (SPCM UT excessive depth)

This QA Inspector was notified via email for verification of B – CWR1981 R0 at 0900 hours the following was observed:

- The component for verification was identified as VP3014-001-041
- Weld repair was to be performed on locations where rejectable indications were found by ultrasonic testing

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- ZPMC CWI Chen Xi was present on site to direct and record all repair work.

B-CWR 1821 Rev 0

This QA Inspector was notified via email for verification of B – CWR1821 R0 at 0940 hours the following was observed:

- The component for verification was identified as FB3272
- Base metal repair was required after removal of tack welds on stiffeners to resolve UT issues
- ZPMC CWI Li Zhi Jiang was present on site to direct and record all repair work.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Dsouza,Christopher	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
